

DART AEROSPACE LTD	Work Order:	23166
Description: Pedal Lock Base	Part Number:	D3416-1
Dwg: D3416 Rev. A	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	u	05.05.04	10
2	MV	Cut blanks: 1.250" x 2.00" x 6.075" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) (M6061T6B2.000x01.250) Identify for D3416-1 Batch: <u>M15733</u>	SA	05.05.07	10
3	MV	Machine as per Folio FA521 and Dwg D3416 Identify as D3416-1	SA	05.05.08	10
4	QC2	Inspect parts as they come off the CNC machine	SA	05.05.08	10
5	QC8	Second check	SA	05.05.08	10
6	MV	Deburr	SA	05.05.08	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05.05.10	11
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask threaded holes	MM	05.05.11	11
9	QC3	Inspect Powder Coat	SB	05/05/11	11
10	QC5	Inspect work to Step 9	2	05.05.12	11
11	ST	Identify and Stock	2	05.05.12	11
12	AC	Cost / part <u>25.90</u>	AB	05/05/16	11
13	DC	Close W/O <u>25.90</u> Inspect Level 21	AB	05.05.16	11

Rev	Date	Change	Revised By	Approved
A	05.04.06	New issue	KJ/JLM	

RELEASED
05.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 04, 2005
03:47 pm

Work Order No	: 0023166	Department Code:	
Project Name	: D3416-1	Burden Flags	: NNNNNNNN
Project For	: WK519	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3416-1	Invoice Number	:
Description	: Pedal Lock Base	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 05-04-05		
Est Finish Date	: 05-10-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00


DART AEROSPACE LTD		Work Order: 23/66
Description:		Part Number: 3416-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.94	$\pm .030$	5.940	/			
5.188	$\pm .010$	5.190	/			
2.893	$\pm .010$	2.892	/			
2.403	--	2.404	/			
Ø.185	$\pm .005$ $\pm .000$	Ø.186	/			
1.075	$\pm .010$	1.075	/			
.500	--	.500	/			
7°		7°	/			
2.00	$\pm .030$	1.999	/			
.50	--	.510	/			
.750	$\pm .010$.755	/			
1.25	$\pm .030$	1.251	/			
.485	$\pm .010$.485	/			
2.380	--	2.380	/			
1.458	--	1.462	/			
.063	--	.063	/			
.286	--	.276	/			Control measure acc.
45°		45°	/			
1.450	--	1.449	/			

Measured by: SD
Date: 03.05.08

Audited by: 
Date: 05.05.08

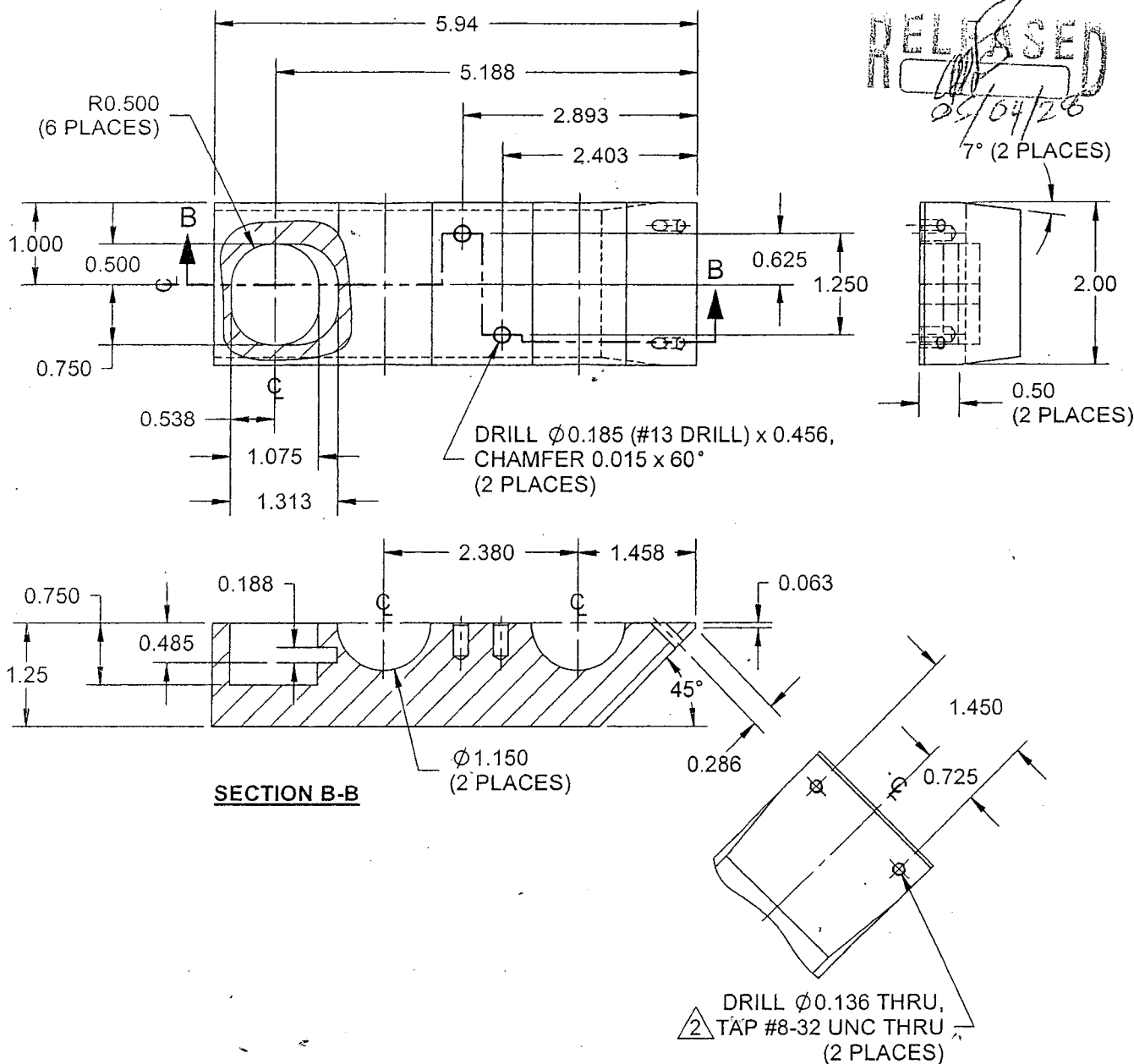
Prototype Approval: N/A
Date:

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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CONTROLLED COPY



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3416	REV. A SHEET 2 OF 3
DATE 05.03.14		TITLE MD500 (369) PEDAL LOCK	SCALE 1:2



D3416-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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